

**WE CLAIM:**

- 1           1.     A multiple unit dosage form comprising multiple units, each unit  
2 comprising: at least one core having an outer surface;  
3           a first coating layer surrounding at least a portion of the outer surface of the core  
4 and having an outer surface, the coating layer including one or both of one or more active  
5 pharmaceutical ingredients and one or more rate controlling polymers; and  
6           an outer layer, the outer layer comprising a material that is one or both of elastic  
7 and compressible.
- 1           2.     The multiple unit dosage form of claim 1, wherein the core includes the one  
2 or more rate controlling polymers.
- 1           3.     The multiple unit dosage form of claim 1, wherein the core includes the one  
2 or more active pharmaceutical ingredients.
- 1           4.     The multiple unit dosage form of claim 1, wherein the core includes one or  
2 more of sugar, a non-pareil seed, microcrystalline cellulose, celphere, sand silicon dioxide,  
3 glass, plastic, polystyrene, hydroxypropyl methylcellulose.
- 1           5.     The multiple unit dosage form of claim 4, wherein the sugar comprises one  
2 or more of glucose, mannitol, lactose, xylitol, dextrose, and sucrose.
- 1           6.     The multiple unit dosage form of claim 1, wherein the core comprises one  
2 or more of an insoluble material, a soluble material, and a swellable material.
- 1           7.     The multiple unit dosage form of claim 1, wherein the rate controlling  
2 polymer comprises one or more of cellulosic polymers, methacrylic acid polymers, and  
3 waxes.
- 1           8.     The multiple unit dosage form of claim 1, wherein the rate controlling  
2 polymer comprises one or more of ethylcellulose, hydroxypropyl methylcellulose,  
3 hydroxypropyl cellulose, methylcellulose, carboxymethylcellulose,  
4 hydroxymethylcellulose, and hydroxyethylcellulose, hydroxypropylmethyl phthalate,  
5 cellulose acetate phthalate, and cellulose acetate trimellitate.
- 1           9.     The multiple unit dosage form of claim 1, wherein the one or more active  
2 pharmaceutical ingredients comprises one or more of antidepressants, antidiabetics,

3 antiulcers, analgesics, antihypertensives, antibiotics, antipsychotics, antineoplastics,  
4 antimuscarinics, diuretics, antimigraine agents, antivirals, anti-inflammatory agents,  
5 sedatives, antihistaminics, antiparasitic agents, antiepileptics and lipid lowering agents.

1 10. The multiple unit dosage form of claim 1, wherein the one or more active  
2 pharmaceutical ingredients comprise one or more of enalapril, captopril, benazepril,  
3 lisinopril, ranitidine, famotidine, ranitidine bismuth citrate, diltiazem, propranolol,  
4 verapamil, nifedipine, acyclovir, ciprofloxacin, simvastatin, atorvastatin, lovastatin,  
5 venlafaxine, citalopram, paroxetine, selegiline, midazolam, fluoxetine, acarbose,  
6 buspirone, nimesulide, captopril, nabumetone, glimepiride, glipizide, etodolac, nefazodone  
7 and their pharmaceutically acceptable salts.

1 11. The multiple unit dosage form of claim 1, wherein the one or more active  
2 pharmaceutical ingredients comprises one or both of glipizide and venlafaxine or their  
3 salts.

1 12. The multiple unit dosage form of claim 1, wherein the core includes the  
2 rate controlling polymer and the active pharmaceutical ingredient.

1 13. The multiple unit dosage form of claim 1, wherein the first coating layer  
2 further includes the active pharmaceutical ingredient.

1 14. The multiple unit dosage form of claim 1, wherein the first coating layer  
2 includes the one or more active pharmaceutical ingredients.

1 15. The multiple unit dosage form of claim 1, further comprising one or more  
2 additional layers, wherein the additional layers are positioned between (a) one or more of  
3 the core and the first coating layer and (b) surrounding at least a portion of the first coating  
4 layer,

5 wherein the one or more additional layers comprise one or more of a seal coat, a  
6 film forming layer, a rate controlling polymer, and an active pharmaceutical ingredient.

1 16. The multiple unit dosage form of claim 15, wherein the seal coat comprises  
2 one or more of hydroxypropyl methylcellulose, polyvinyl pyrrolidone, and methacrylic  
3 acid copolymers.

1           17.     The multiple unit dosage form of claim 15, wherein the film forming layer  
2 includes one or more of ethyl cellulose, hydroxypropyl methylcellulose, hydroxypropyl  
3 cellulose, methyl cellulose, carboxymethylcellulose, hydroxymethylcellulose,  
4 hydroxyethylcellulose, hydroxypropyl methyl phthalate, cellulose acetate, cellulose  
5 acetate trimellitate, cellulose acetate phthalate, waxes, polyethylene glycol, and  
6 methacrylic acid polymers.

1           18.     The multiple unit dosage form of claim 1, wherein the material in the outer  
2 layer comprises one or more wax materials.

1           19.     The multiple unit dosage form of claim 18, wherein the wax material  
2 comprises one or more polyethylene glycols (PEGs).

1           20.     The multiple unit dosage form of claim 19, wherein the one or more  
2 polyethylene glycols (PEGs) differ by molecular weight.

1           21.     The multiple unit dosage form of claim 20, wherein the polyethylene glycol  
2 (PEG) comprises one or more of PEG 600, PEG 4000, PEG 6000, PEG 8000, and PEG  
3 20000.

1           22.     The multiple unit dosage form of claim 19, wherein the waxy material  
2 comprises from about 1% to about 15% by weight of the total dosage form weight.

1           23.     The multiple unit dosage form of claim 19, wherein the waxy material  
2 comprises from about 1% to about 100% by weight of the weight of the core and the first  
3 coating layer.

1           24.     The multiple unit dosage form of claim 19, wherein the waxy material is  
2 applied to each unit as a solution, suspension, dispersion, or hot melt technique.

1           25.     The multiple unit dosage form of claim 24, wherein the solution,  
2 suspension, or dispersion is made using a solvent,

1           wherein the solvent comprises one or more of methylene chloride, isopropyl  
2 alcohol, acetone, methanol, ethanol, and water.

1           26.     The multiple unit dosage form of claim 1, wherein the active  
2     pharmaceutical ingredient comprises glipizide and is in one or both of the core and the  
3     first coating layer.

1           27.     The multiple unit dosage form of claim 26, further comprising a buffering  
2     agent with the glipizide in one or both of the core and the first coating layer.

1           28.     The multiple unit dosage form of claim 27, wherein the buffering agent  
2     comprises one or more of dibasic sodium phosphate, sodium ascorbate, meglumine,  
3     sodium citrate trimethanolamine, sodium hydroxide, potassium hydroxide, calcium  
4     hydroxide, magnesium hydroxide, ammonia, tertiary sodium phosphate, diethanolamine,  
5     ethylenediamine, and L-lysine.

1           29.     The multiple unit dosage form of claim 1, wherein one or more of the core  
2     and the first coating layer includes one or more pharmaceutically acceptable excipients.

1           30.     The multiple unit dosage form of claim 29, wherein the pharmaceutically  
2     acceptable excipients includes surfactants, binders, diluents, disintegrants, lubricants,  
3     glidants, plasticizers, stabilizers, and coloring agents.

1           31.     The multiple unit dosage form of claim 30, wherein the surfactants include  
2     one or more of a non-ionic surfactant, an ionic surfactant, mono fatty acid esters of  
3     polyoxyethylene sorbitan, polyoxyethylene (20) sorbitan monooleate (Tween 80),  
4     polyoxyethylene (20) sorbitan monostearate (Tween 60), polyoxyethylene (20) sorbitan  
5     monolaurate (Tween 20), an anionic surfactant, sodium lauryl sulfate, polyoxyethylene  
6     castor oil derivative, polyoxyethyleneglycerol triiricinoleate castor oil, polyoxyl 35 castor  
7     oil, Cremophor EL, and Vitamin E TPGS, d-alpha-tocopheryl polyethylene glycol 1000  
8     succinate, polyethoxylated fatty acids and their derivatives, polyethylene glycol 400  
9     distearate, polyethylene glycol - 20 dioleate, polyethylene glycol 4-150 mono dilaurate,  
10    polyethylene glycol -20 glyceryl stearate, alcohol - oil transesterification products,  
11    polyethylene glycol - 6 corn oil, polyglycerized fatty acids, polyglyceryl - 6 pentaoleate,  
12    propylene glycol fatty acid esters, propylene glycol monocaprylate, mono and  
13    diglycerides, glyceryl ricinoleate, sterol and sterol derivatives, sorbitan fatty acid esters  
14    and their derivatives, polyethylene glycol - 20 sorbitan monooleate and sorbitan  
15    monolaurate, polyethylene glycol alkyl ether or phenols, polyethylene glycol - 20 cetyl  
16    ether, polyethylene glycol - 10 - 100 nonyl phenol, sugar esters, sucrose monopalmitate,

17 polyoxyethylene – polyoxypropylene block copolymers, poloxamer, sodium caproate,  
18 sodium glycocholate, soy lecithin, sodium stearyl fumarate, propylene glycol alginate,  
19 octyl sulfosuccinate disodium, and palmitoyl carnitine.

1 32. The multiple unit dosage form of claim 30, wherein the binders includes  
2 one or more of methyl cellulose, hydroxypropyl cellulose, hydroxypropyl methylcellulose,  
3 polyvinylpyrrolidone, gelatin, gum arabic, ethyl cellulose, polyvinyl alcohol, pullulan,  
4 pregelatinized starch, agar, tragacanth, sodium alginate, and propylene glycol.

1 33. The multiple unit dosage form of claim 30, wherein the diluents include  
2 one or more of calcium carbonate, calcium phosphate-dibasic, calcium phosphate-tribasic,  
3 calcium sulfate, microcrystalline cellulose, silicified microcrystalline cellulose, cellulose  
4 powdered, dextrates, dextrans, dextrose excipients, fructose, kaolin, lactitol, lactose,  
5 mannitol, sorbitol, starch, starch pregelatinized, sucrose, sugar compressible, and sugar  
6 confectioners.

1 34. The multiple unit dosage form of claim 30, wherein the disintegrants  
2 include one or more of starch, croscarmellose, crospovidone, and sodium starch glycolate.

1 35. The multiple unit dosage form of claim 30, wherein the lubricants and  
2 glidants include one or more of colloidal anhydrous silica, stearic acid, magnesium  
3 stearate, calcium stearate, talc, hydrogenated castor oil, sucrose esters of fatty acid,  
4 microcrystalline wax, yellow beeswax, and white beeswax.

1 36. The multiple unit dosage form of claim 30, wherein the plasticizers include  
2 one or more of polyethylene glycol, triethyl citrate, triacetin, diethyl phthalate, and dibutyl  
3 sebacate and the stabilizers include one or more of antioxidants, buffers, and acids.

1 37. The multiple unit dosage form of claim 1, wherein the dosage form  
2 comprises a tablet.

1 38. The multiple unit dosage form of claim 37, wherein the tablet further  
2 includes one or more pharmaceutically acceptable excipients around the individual units.

1 39. The multiple unit dosage form of claim 1, wherein the dosage form  
2 comprises a capsule.

1           40.     The multiple unit dosage form of claim 1, wherein the active  
2 pharmaceutical ingredients comprise one or more of atorvastatin and amlodipine,  
3 metformin and glipizide, simvastatin and ramipril, simvastatin and amlodipine, metformin  
4 XL and glipizide XL, ramipril and atorvastatin, ramipril and amlodipine, metformin XL  
5 and glimiperide, fosinopril and amlodipine.

1           41.     A process for the preparation of a multiple unit dosage form, the process  
2 comprising:

3           providing at least one core having an outer surface;

4           forming a coated core by applying one or more coating layers to the core such that  
5 the one or more coating layers surround at least a portion of the outer surface of the core  
6 or the coating layers;

7           forming an individual unit by applying a waxy material to the coated core to form a  
8 wax layer;

9           combining one or more units to form a multiple unit dosage form,

10          wherein one or both of the core and the coating layers includes one or more rate  
11 controlling polymers and active pharmaceutical ingredients.

1           42.     The process of claim 41, further comprising applying one or both of a seal  
2 layer or a film forming layer between the core and the coating layer, between the one or  
3 more coating layers, and between the one or more coating layers and the wax layer.

1           43.     The process of claim 41, wherein the waxy material comprises one or more  
2 polyethylene glycols (PEGs) of one or more molecular weights.

1           44.     The process of claim 43, wherein the polyethylene glycols (PEG) comprise  
2 one or more of PEG 600, PEG 4000, PEG 6000, PEG 8000, and PEG 20000.

1           45.     The process of claim 41, wherein the waxy material comprises from about  
2 1% to about 15% by weight of the total dosage form weight.

1           46.     The process of claim 41, wherein the waxy material comprises from about  
2 1% to about 100% by weight of the weight of the core and the one or more coating layers.

1           47.     The process of claim 41, wherein applying the waxy material comprises  
2 applying a coating of a solid waxy material by using a hot melt technique.

1           48.     The process of claim 41, wherein applying the waxy material comprises  
2     applying a coating of waxy material by using as one or more of a solution, a suspension,  
3     and a dispersion.

1           49.     The process of claim 48, wherein the solution or the suspension is prepared  
2     in a solvent.

1           50.     The process of claim 49, wherein the solvent is selected from one or more  
2     of methylene chloride, isopropyl alcohol, acetone, methanol, ethanol, and water.

1           51.     The process of claim 41, wherein the core comprises an inert core.

1           52.     The process of claim 41, wherein the core comprises one or more  
2     pharmaceutically acceptable excipients.

1           53.     The process of claim 41, wherein the core comprises one or more active  
2     pharmaceutical ingredients.

1           54.     The process of claim 41, wherein the one or more active pharmaceutical  
2     ingredients comprises one or more of antidepressants, antidiabetics, antiulcers, analgesics,  
3     antihypertensives, antibiotics, antipsychotics, antineoplastics, antimuscarinics, diuretics,  
4     antimigraine agents, antivirals, anti-inflammatory agents, sedatives, antihistaminics,  
5     antiparasitic agents, antiepileptics and lipid lowering agents.

1           55.     The process of claim 41, wherein the one or more active pharmaceutical  
2     ingredients comprise one or more of enalapril, captopril, benazepril, lisinopril, ranitidine,  
3     famotidine, ranitidine bismuth citrate, diltiazem, propranolol, verapamil, nifedipine,  
4     acyclovir, ciprofloxacin, simvastatin, atorvastatin, lovastatin, venlafaxine, citalopram,  
5     paroxetine, selegiline, midazolam, fluoxetine, acarbose, buspirone, nimesulide, captopril,  
6     nabumetone, glimepiride, glipizide, etodolac, nefazodone and their pharmaceutically  
7     acceptable salts.

1           56.     The process of claim 41, wherein the core is prepared by extrusion-  
2     spheronization.

1           57.     The process of claim 56, wherein the extrusion-spheronization process  
2     comprises:

3 granulating an inert core material with or without other pharmaceutical excipients  
4 with a binder solution to form a wet mass;  
5 passing the wet mass through an extruder to form extrudates; and  
6 spheronizing the extrudates.

1 58. The process of claim 41, wherein the core is prepared by granulation.

1 59. The process of claim 58, wherein the granulation process comprises wetting  
2 a dry mix of core material with or without other pharmaceutical excipients with a binder  
3 solution.

1 60. The process of claim 41, wherein the units are prepared by coating the  
2 cores with active pharmaceutical ingredients and rate controlling polymers.

1 61. The process of claim 41, wherein the units are prepared by coating cores  
2 with a first layer comprising an active pharmaceutical ingredient and a second outer layer  
3 comprising a rate controlling polymer.

1 62. The process of claim 41, further comprising applying a seal coat or a film  
2 forming layer between the core and the subsequent layers or between a layer comprising  
3 an active pharmaceutical ingredient and a layer comprising a release rate controlling  
4 polymer

1 63. The process of claim 41, wherein the rate controlling polymer comprises  
2 one or more of cellulosic polymers, methacrylic acid polymers, waxes, ethylcellulose,  
3 hydroxypropyl methylcellulose, hydroxypropyl cellulose, methylcellulose,  
4 carboxymethylcellulose, hydroxymethylcellulose, and hydroxyethylcellulose,  
5 hydroxypropylmethyl phthalate, cellulose acetate phthalate, and cellulose acetate  
6 trimellitate.

1 64. The process of claim 41, wherein the active pharmaceutical ingredient  
2 comprises venlafaxine.

1 65. The process of claim 41, wherein the active pharmaceutical ingredient  
2 comprises glipizide.

1 66. The process of claim 41, wherein the dosage form comprises a tablet.



1           67.     The process of claim 41, wherein the dosage form comprises a capsule.

1           68.     A method for preparing a modified release multiple unit dosage form, the  
2 method comprising:

3           providing a core having a coating, wherein one or both of the core and the coating  
4 include one or more of rate controlling polymers and active pharmaceutical ingredients;  
5           forming individual units by coating the coated core with a coating material that is  
6 one or both of compressible and elastic; and  
7           forming the dosage form by combining one or more individual units.

1           69.     The method of claim 68, wherein combining one or more individual units  
2 comprises compressing the individual units into a tablet

1           70.     The method of claim 68, wherein combining one or more individual units  
2 comprises filling the individual units into a capsule or sachet.

1           71.     The method of claim 68, wherein the coating material comprises a waxy  
2 material.

1           72.     The method of claim 68, wherein the coating material comprises a  
2 polyethylene glycol.

1           73.     A method of treating a medical condition, the method comprising  
2 administering a multiple unit dosage form for oral ingestion, each unit comprising a core,  
3 one or more layers surrounding the core, and an outer layer, wherein  
4           the core comprises one or more of a pharmaceutically acceptable excipients, an  
5 active pharmaceutical ingredient, and a rate controlling polymer,  
6           the one or more layers comprises one or more of a pharmaceutically acceptable  
7 excipient, an active pharmaceutical ingredient, a rate controlling polymer, a sealing layer,  
8 and a film forming layer, and  
9           the outer layer comprises a material that is one or both of compressible and elastic  
10 to partially or completely absorb a force exerted in forming the multiple unit dosage form  
11 by combining the units.

1           74.     The method of claim 73, wherein the material of the outer layer comprises  
2 a waxy material.

1           75.     The method of claim 74, wherein the waxy material comprises one or more  
2 polyethylene glycols of different molecular weights.

1           76.     The method of claim 73, wherein the dosage form comprises a tablet.

1           77.     The method of claim 73, wherein the dosage form comprises a capsule.

1           78.     A multiple unit dosage form comprising multiple units, each unit  
2 comprising:  
3           at least one core having an outer surface and comprising one or more one active  
4 pharmaceutical ingredients; and  
5           a coating layer surrounding at least a portion of the outer surface of the core,  
6 having an outer surface and comprising a waxy material.

1           79.     The multiple unit dosage form of claim 78, wherein the waxy material  
2 comprises one or more polyethylene glycols of different molecular weights.

1           80.     The multiple unit dosage form of claim 78, wherein the dosage form  
2 comprises a tablet.

1           81.     The multiple unit dosage form of claim 78, wherein the dosage form  
2 comprises a capsule.

1           82.     A combination drug, multiple unit dosage form comprising:  
2 first units; and  
3 second units,  
4           each first unit comprising at least one core having an outer surface, a first  
5 coating layer surrounding at least a portion of the outer surface of the core and  
6 having an outer surface, and an outer layer surrounding at least a portion of an  
7 outer surface of the first coating layer, the first coating layer including a first active  
8 pharmaceutical ingredient,  
9           each second unit comprising at least one core having an outer surface, a  
10 first coating layer surrounding at least a portion of the outer surface of the core and  
11 having an outer surface, and an outer layer surrounding at least a portion of an  
12 outer surface of the first coating layer, the first coating layer including a second  
13 active pharmaceutical ingredient,

14                    wherein one or both of the cores and the coating layers comprise a rate  
15                    controlling polymer, and  
16                    one or both of the outer layers comprise a waxy material,.

1                    83.    The combination drug, multiple unit dosage form of claim 82, wherein the  
2                    waxy material comprises one or more polyethylene glycols.

1                    84.    The combination drug, multiple unit dosage form of claim 82, wherein the  
2                    dosage form comprises a tablet.

1                    84.    The combination drug, multiple unit dosage form of claim 82, wherein the  
2                    dosage form comprises a capsule.

1                    85.    A multiple unit dosage form comprising multiple units, each unit  
2                    comprising:  
3                    at least one core having an outer surface;  
4                    a first coating layer surrounding at least a portion of the outer surface of the core  
5                    and having an outer surface, the coating layer including glipizide or its pharmaceutically  
6                    acceptable salt and optionally one or more rate controlling polymers.

1                    86.    The multiple unit dosage form of claim 85, wherein the pharmaceutically  
2                    acceptable salt comprises one or more of mineral acid salts, organic acid salts, and  
3                    organosulphonic acid salts.

1                    87.    The multiple unit dosage form of claim 85, wherein the core includes one  
2                    or more of sugar, a non-pareil seed, microcrystalline cellulose, celphere, sand silicon  
3                    dioxide, glass, plastic, polystyrene, hydroxypropyl methylcellulose.

1                    88.    The multiple unit dosage form of claim 87, wherein the sugar comprises  
2                    one or more of glucose, mannitol, lactose, xylitol, dextrose, and sucrose.

1                    89.    The multiple unit dosage form of claim 85, wherein the core comprises one  
2                    or more of an insoluble material, a soluble material, and a swellable material.

1                    90.    The multiple unit dosage form of claim 85, wherein the rate controlling  
2                    polymer comprises one or more of cellulosic polymers, methacrylic acid polymers, waxes,  
3                    ethylcellulose, hydroxypropyl methylcellulose, hydroxypropyl cellulose, methylcellulose,

4 carboxymethylcellulose, hydroxymethylcellulose, and hydroxyethylcellulose,  
5 hydroxypropylmethyl phthalate, cellulose acetate phthalate, and cellulose acetate  
6 trimellitate.

1 91. The multiple unit dosage form of claim 85, wherein the core includes rate  
2 controlling polymer and glipizide.

1 92. The multiple unit dosage form of claim 85, further comprising one or more  
2 additional layers, wherein the additional layers are positioned between (a) one or more of  
3 the core and the first coating layer and (b) surrounding at least a portion of the first coating  
4 layer,

5 wherein the one or more additional layers comprise one or more of a seal coat, a  
6 film forming layer, a rate controlling polymer, and an active pharmaceutical ingredient.

1 93. The multiple unit dosage form of claim 92, wherein the seal coat comprises  
2 one or more of hydroxypropyl methylcellulose, polyvinyl pyrrolidone, and methacrylic  
3 acid copolymers and the film forming layer comprises one or more of ethyl cellulose,  
4 hydroxypropyl methylcellulose, hydroxypropyl cellulose, methyl cellulose,  
5 carboxymethylcellulose, hydroxymethylcellulose, hydroxyethylcellulose, hydroxypropyl  
6 methyl phthalate, cellulose acetate, cellulose acetate trimellitate, cellulose acetate  
7 phthalate, waxes, polyethylene glycol, and methacrylic acid polymers.

1 94. The multiple unit dosage form of claim 85, further comprising an outer  
2 layer, the outer layer comprising a material that is one or both of elastic and compressible.

1 95. The multiple unit dosage form of claim 94, wherein the material in the  
2 outer layer comprises one or more wax materials.

1 96. The multiple unit dosage form of claim 95, wherein the wax material  
2 comprises one or more polyethylene glycols (PEGs).

1 97. The multiple unit dosage form of claim 85, further comprising a buffering  
2 agent with the glipizide in the first coating layer.

1 98. The multiple unit dosage form 97, wherein the buffering agent comprises  
2 one or more of dibasic sodium phosphate, sodium ascorbate, meglumine, sodium citrate  
3 trimethanolamine, sodium hydroxide, potassium hydroxide, calcium hydroxide,

4 magnesium hydroxide, ammonia, tertiary sodium phosphate, diethanolamine,  
5 ethylenediamine, and L-lysine.

1 99. The multiple unit dosage form of claim 85, wherein the dosage form  
2 comprises a tablet.

1 100. The multiple unit dosage form of claim 85, wherein the dosage form  
2 comprises a capsule.

1 101. A modified release multiple unit system comprising units of glipizide,  
2 wherein the units comprise:  
3 an inert core;  
4 a drug layer surrounding the inert core, the drug layer comprising glipizide; and  
5 a rate controlling polymer layer surrounding the drug layer.

1 102. The modified release multiple unit system of claim 101, wherein the system  
2 comprises a tablet.

1 103. The modified release multiple unit system of claim 101, wherein the system  
2 comprises a capsule.

1 104. A modified release multiple unit system comprising units of glipizide  
2 wherein the units comprise:  
3 an inert core;  
4 a drug layer surrounding the inert core;  
5 a rate controlling polymer layer surrounding the drug layer; and  
6 a waxy layer surrounding the drug layer.

1 105. The modified release multiple unit system of claim 104, wherein the units  
2 can be compressed into tablet, or filled into a capsule or a sachet; without affecting the  
3 desired release characteristics of drug.

1 106. The modified release multiple unit system of claim 104, wherein the system  
2 comprises a tablet.

1 107. The modified release multiple unit system of claim 104, wherein the system  
2 comprises a capsule.

1           108. A modified release multiple unit system comprising units of venlafaxine,  
2 wherein the units comprise:  
3 an inert core;  
4 a drug layer surrounding the inert core; and  
5 a rate controlling polymer layer surrounding the drug layer.

1           109. The modified release multiple unit system of claim 108, wherein the system  
2 comprises a tablet.

1           110. A modified release multiple unit system comprising units of venlafaxine  
2 wherein the units comprise:  
3 an inert core;  
4 a drug layer surrounding the inert core;  
5 a rate controlling polymer layer surrounding the drug layer; and  
6 a waxy layer surrounding the rate controlling polymer layer.

1           111. The modified release multiple unit system of claim 110, wherein the units  
2 can be compressed into tablet without affecting the desired release characteristics of drug.

1           112. A modified release multiple unit system comprising units of a drug wherein  
2 the units comprise:  
3 an inert core;  
4 a drug layer surrounding the inert core;  
5 a rate controlling polymer layer surrounding the drug layer; and  
6 a waxy layer surrounding the rate controlling polymer layer.

1           113. The modified release multiple unit system of claim 112, wherein the units  
2 can be compressed into tablet, or filled in capsule or sachet; without affecting the desired  
3 release characteristics of drug.

1           114. A process for the preparation of a modified release multiple unit system of  
2 a drug, the process comprising the steps of:  
3 coating inert pellets with a drug and rate controlling polymer layer;  
4 coating with a waxy layer;  
5 optionally blending with pharmaceutically acceptable excipients;  
6 compressing into a tablet, or filling into a capsule or a sachet of suitable size.

1           115. A process for the preparation of a modified release multiple unit system of  
2 drug, the process comprising the steps of:  
3           coating inert pellets with a drug and rate controlling polymer layer;  
4           coating with a waxy layer;  
5           optionally blending with pharmaceutically acceptable excipients;  
6           compressing into tablet of suitable size.

1           116. The process of claim 115, wherein the drug comprises venlafaxine or a  
2 pharmaceutically acceptable salt.

1           117. A process for the preparation of modified release multiple unit system of  
2 drug comprising the steps of:  
3           coating drug containing cores with a rate controlling polymer layer;  
4           coating the rate controlling polymer layer with a waxy layer;  
5           optionally blending with pharmaceutically acceptable excipients; and  
6           compressing into tablet, or filling into capsule or sachet of suitable size.